

Work Order ID 61235

Wednesday, August 11, 2010 11:30:44 AM



Page 1

Item ID: D4149-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Plate, Aft

Stop



Start Date: 8/12/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 8/26/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: MSDate: 10-8-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4149	B
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100 0.00



Waterjet

Memo

0.00

BS 10-8-16

FLOW CNC Waterjet

304.105

Cut as per dwg D4149

Prog Rev: BDwg Rev: B

Deburr as required

11

110



QC2- Inspect parts off machine FAI/FAIB

0.00

BS 10-8-16

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

8/10/08/17

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

Packaging

Identify as per dwg & Stock Location: SI123

0.00

0.00

X11 BR
10/08/17

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/08/17 AF

CMF

10-8-11

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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 11, 2010 11:30:43 AM

Page 1
1

Work Order ID: 61235



Parent Item: D4149-1



Parent Item Name: Crosstube Lug Plate, Aft

Start Date: 8/12/2010

Required Date: 8/26/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased		No		100	sf	82.3023	0.1355	1.426316	1.5		

Location	Loc Qty	Loc Code
MAT	82.3023	
114799	82.3023	114799

(N)

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DART AEROSPACE LTD		Work Order: 61235
Description: Aft Crosstube Lug Plate	Part Number:	D4149-1
Inspection Dwg: D4149 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	✗		✓	RB02
Ø0.191	+0.005/-0.001	.192	✗		✓	
Ø0.257	+0.006/-0.001	.257	✗		✓	
Ø0.38	+0.006/-0.001	.379	✗		✓	
0.380	+/-0.010	.380	✗		✓	
0.469	+/-0.010	.471	✗		✓	
0.310	+/-0.010	.309	✗		✓	
0.750	+/-0.010	.748	✗		✓	
3.25	+/-0.030	3.246	✗		✓	
0.65	+/-0.030	.644	✗		✓	
0.63	+/-0.030	.637	✗		✓	
5.46	+/-0.030	5.46	✗		✓	
3.80	+/-0.030	3.80	✗		✓	
2.13	+/-0.030	2.13	✗		✓	
1.313	+/-0.010	1.312	✗		✓	
0.625	+/-0.010	.624	✗		✓	
0.375	+/-0.010	.373	✗		✓	
1.175	+/-0.010	1.179	✗		✓	
0.752	+/-0.010	.754	✗		✓	
1.588	+/-0.010	1.586	✗		✓	
1.587	+/-0.010	1.586	✗		✓	
11.15	+/-0.030	11.158	✗		✓	
0.750	+/-0.010	.760	✗		T HB01	
1.55	+/-0.030	1.555	✗		✓	
1.12	+/-0.030	1.132	✗		✓	
8.42	+/-0.030	8.420	✗		✓	
2.70	+/-0.030	2.701	✗		✓	
0.125	+/-0.010	.119	✗		✓	

Measured by: <i>RB</i>	Audited by: <i>S</i>	Preliminary Approval: N/A
Date: 10-8-16	Date: 10/05/17	Date: N/A

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ <i>bj</i>	<i>MM</i>

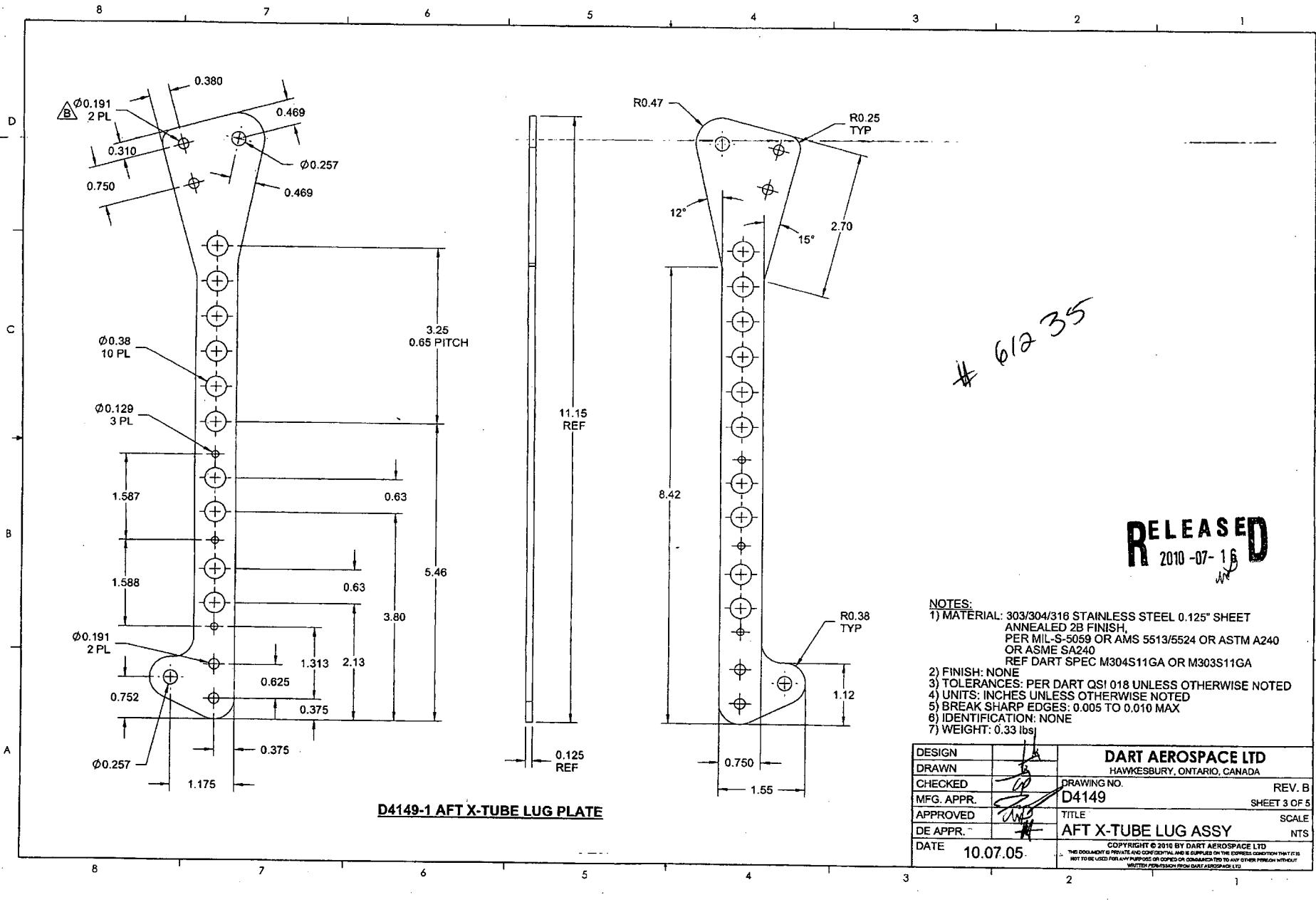
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